

Work Order ID 121024

July-15-14 10:37:48 AM

121024

Page 1

Item ID: D4463-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Upper Cut Out
 Start Date: 6/23/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/23/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 140623 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4463	D

100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg Prog rev: <u>5</u> Dwg rev: <u>2</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

EB
14/07/23
DAS
27
9-89

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 Start Date: 6/23/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/23/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00			DAS 30 9-89	6			14/07/24
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00			DAS 27 9-89 14/7/24	6			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	76	14-7-24	

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/23/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 6/23/14 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC7-Inspect Chemical Conversion Coat	0.00
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160

QC Memo

Quality Control

170 Identify as per dwg & Stock Location: WHA EO30.00

170

Packaging	Memo	0.00
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Packaging	14.6
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180	QC21- Final Inspection - Work Order Release	0.00
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180

QC	Memo	0.00
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Quality Control

MLJ 14-07-25

MLS 14-07-25

Picklist Print

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Work Order ID: 121024

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Parent Item: D4463-5

D4463-5

Parent Item Name: Tank Upper Cut Out

Start Date: 6/23/14

Required Date: 6/23/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	751.7880	0.174	1			

M6061T6S 063

6061-T6 .063 Sheet

mm 14/07/23

Location

Loc Qty

Loc Code

MAT021

495.788

M124446

3.7

M126075

4.5

M127006

9

M127420

111.12

M128054

63.468

M128941

81

M129636

223

TPI

256

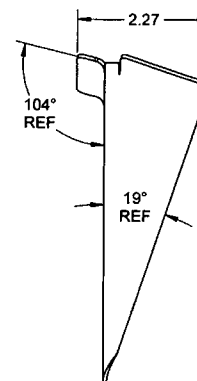
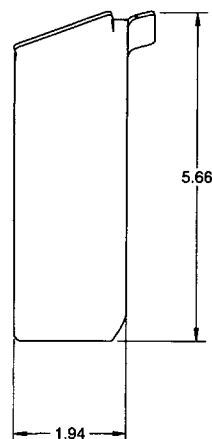
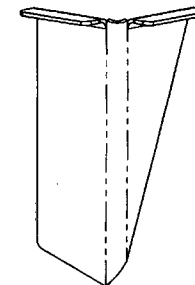
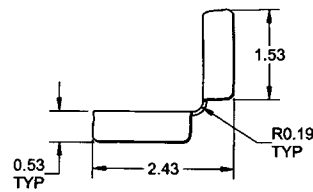
M129637

256

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	mm	Audited by:	EB 27 9-89	Preliminary Approval:	
Date:	17/01/23	Date:	14/02/23	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revE



Wb
121024

D4463-5 TANK UPPER CUT OUT

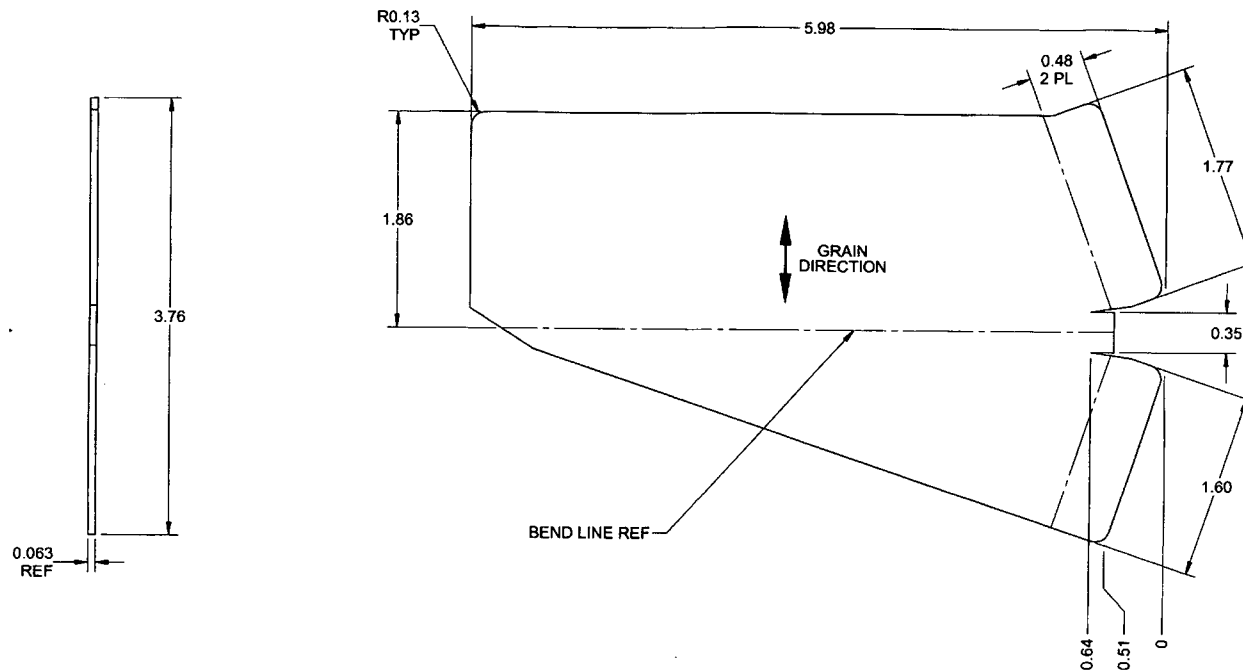
NOTES:

- 1) MATERIAL: MADE FROM D4463-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

RELEASED
2014-06-11

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4463	SHEET 5 OF 14
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	AUX TANK	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4463-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4463-5F-D.XF"

RELEASED
2014-06-11

APPROVED

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DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4463	SHEET 6 OF 14
APPROVED	MP	TITLE	SCALE
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